

Date: Friday, 13/06/2008 1:48:45 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WINDOW		
Job Number	: 39873			Part Number	: D32903		
Estimate Number	: 11176			Drawing Number	: D3290 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/06/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 23/06/2008		
Previous Run	: 35975			Qty:	12	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08 6.13</u>						
Comment	: Est. A 04.08.18 New issue KJ/RF Est. B 06.05.09 Ecn 798 EC Est. C 07.05.29 Thermoform in-house DL Est. D 07.09.28 rev C dwg EC verified by: DD Est. E 07.11.28 Add -Hand finish deburring DL						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	<u>MACRLICES125</u>	1/8" Polycast II Sheet
		64
		Comment: Qty.: 3.1500 sf(s)/Unit Total: 37.8000 sf(s) Polycast II or plexiglass G .125"
		20 108344 <del>108343</del> R 8-6- <del>11</del> 107252 PTO
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3290
		Dwg Rev: <u>C</u> 18 Prog Rev: <u>C</u> 18
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		20 R 8-6- <del>11</del>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		SoS 06/20 + 18 88/06/17 + 18
		Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-3 PAR #: D350-567 Fault Category: Problems Pass / MED STRIKE Waterjet NCR: Yes No DQA: AD Date: 08/07/08 QA: N/C Closed: AD Date: 08/07/08

NCR: 39873		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/17	# 20	During inspection it was found that the operator <del>scraped</del> pulled M&E + ANS. 125" instead of materials. 125"	J 08/06/17	Retrain operator that hexac and Acrylic are not the same SCRAP all P2 Lern	BB 8-6-20	08/06/20	J 08/06/17	J 08/06/17
		R.C. operator error. operator thought it was the same.	J 08/06/17	Windows AND replace with correct mat. MACRYLIC 125" BB 108344 7/18 10725	BB 8-6-20	08/06/20	J 08/06/17	J 08/06/17

NOTE: Date & initial all entries

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Part Number: D32903

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

x18

Without removing protective skin  
remove sharp edge by degurring.

08.06.24 Wh

6.0 THERMOFORMING

THERMOFORMING MACHINE



Comment: 1-THERMOFORM as per Drawing D3290 and Folio FTA001

Dwg. Rev. D 3290

x18

Folio Rev A

08.06.24 Wh

2-Engrave part# & batch#,  
(D3290-3)

08/06/25 DD x18

7.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08.06.24 Wh

Check product for scratches mal-formation or any other non conformances

8.0 QC8

SECOND CHECK



Comment: SECOND CHECK

BB 08/06/25 x18

9.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches if required

BB 08/06/25 x18

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 08/06/25 x18

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA

08/07/03 (1)  
SAP 08/07/03 117

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WINDOW

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Part Number: D32903

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

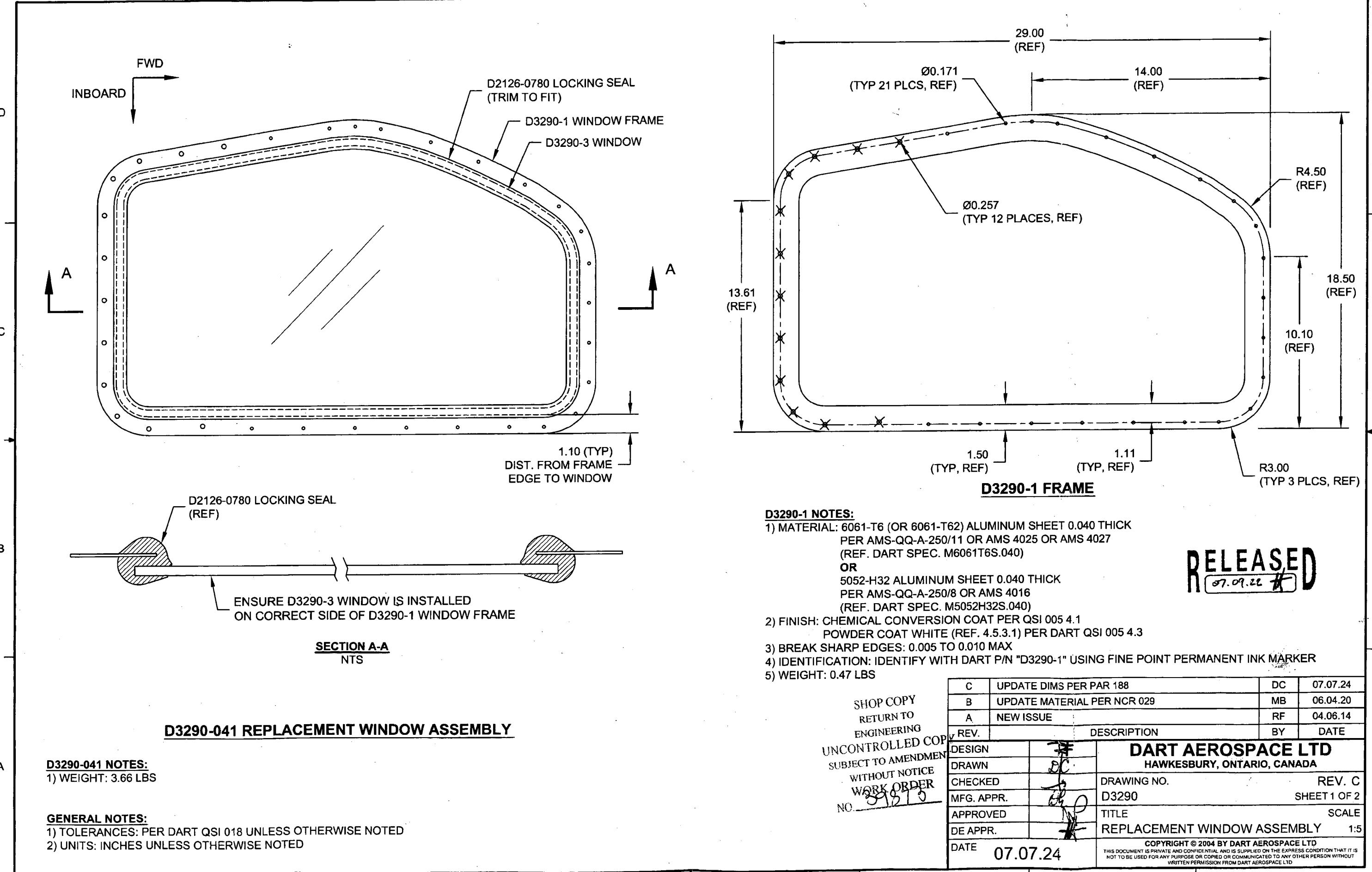
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8

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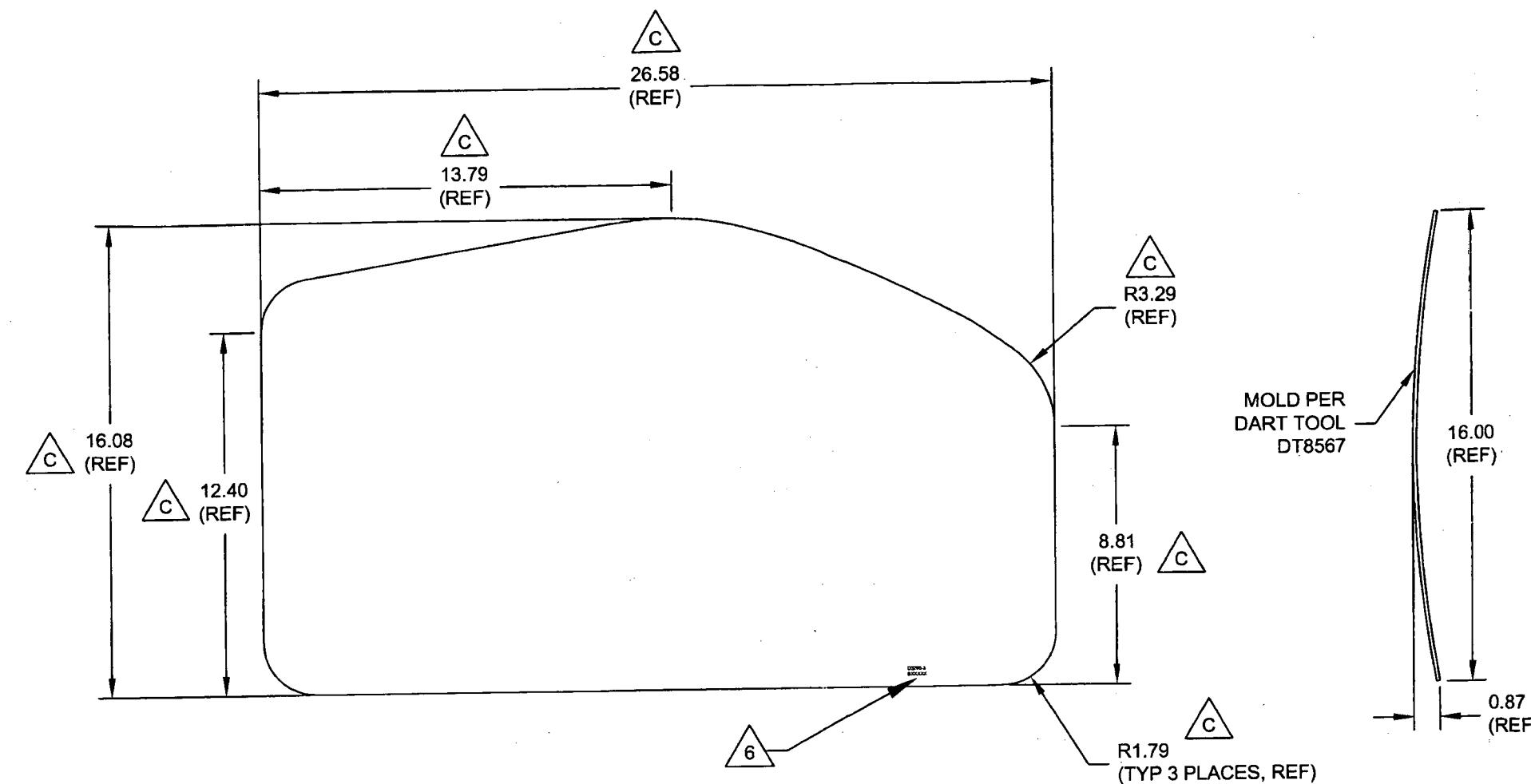
6

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### D3290-3 WINDOW

**D3290-3 NOTES:**

- (B) 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39873

**RELEASED**  
07.09.22

DESIGN	<u>PF</u>	<b>DART AEROSPACE LTD</b>			
DRAWN	<u>JF</u>	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<u>b</u>	DRAWING NO.			
MFG. APPR.	<u>JK</u>	REV. C			
APPROVED	<u>NP</u>	D3290			
DE APPR.	<u>F</u>	SHEET 2 OF 2			
DATE	<u>07.07.24</u>	TITLE	SCALE		
		REPLACEMENT WINDOW ASSEMBLY			
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2

1

A

B

D

C

DART AEROSPACE LTD	Work Order:	39873
Description: WINDOW	Part Number:	D3D90-3
Inspection Dwg: D3D90-3 Rev: C		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	18	Audited by:		Prototype Approval:	✓ A
Date:	8-6-20	Date:	05/06/20	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	